

**WHAT IS CLAIMED IS:**

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- 1 1. A method of manufacturing a personal care product comprising:
  - 2     Applying a grip to a handle of a personal care product, the grip comprising a core and a
  - 3 sheath surrounding the core, the sheath having a hardness greater than the core.
  - 1 2. The method of claim 1 wherein the core is an elastomeric material.
  - 1 3. The method of claim 2 wherein the elastomeric material is a thermoplastic elastomer.
  - 1 4. The method of claim 3 wherein the thermoplastic elastomer is selected from the group
  - 2 consisting of thermoplastic vulcanates (rubber polyolefin blends), polyetheramides,
  - 3 polyesters, styrene-ethylene-butylene-styrene (SEBS) block copolymers, styrene-
  - 4 butadiene-styrene (SBS) block copolymers, partially or fully hydrogenated styrene-
  - 5 butadiene-styrene block copolymers, styrene-isoprene-styrene block copolymers,
  - 6 polyurethanes, polyolefin elastomers, polyolefin plastomers, styrenic based polyolefin
  - 7 elastomers, and compatible mixtures thereof.
  - 1 5. The method of claim 1 wherein the core has a hardness of less than 50 Shore A.
  - 1 6. The method of claim 5 wherein the core has a hardness of less than 25 Shore A.
  - 1 7. The method of claim 6 wherein the core has a hardness of less than 10 Shore A.
  - 1 8. The method of claim 1 wherein the sheath is an elastomeric material.
  - 1 9. The method of claim 8 wherein the elastomeric material is a thermoplastic elastomer.
  - 1 10. The method of claim 9 wherein the thermoplastic elastomer is selected from the group
  - 2 consisting of thermoplastic vulcanates (rubber polyolefin blends), polyetheramides,
  - 3 polyesters, styrene-ethylene-butylene-styrene (SEBS) block copolymers, styrene-
  - 4 butadiene-styrene (SBS) block copolymers, partially or fully hydrogenated styrene-
  - 5 butadiene-styrene block copolymers, styrene-isoprene-styrene block copolymers,

- 6 polyurethanes, polyolefin elastomers, polyolefin plastomers, styrenic based polyolefin  
7 elastomers, and compatible mixtures thereof.
- 1 11. The method of claim 1 wherein the sheath is approximately 0.4 mm to 4.0 mm thick.
- 1 12. The method of claim 11 wherein the sheath is approximately 0.5 mm to 2.0 mm thick.
- 1 13. The method of claim 12 wherein the sheath is approximately 0.5 mm to 1.0 mm thick.
- 1 14. The method of claim 1 wherein the sheath has a hardness of approximately 25 Shore A to  
2 80 Shore A.
- 1 15. The method of claim 14 wherein the sheath has a hardness of approximately 30 Shore A  
2 to 60 Shore A.
- 1 16. The method of claim 15 wherein the sheath has a hardness of approximately 40 Shore A  
2 to 55 Shore A.
- 1 17. The method of claim 1 wherein the personal care product is selected from the group  
2 consisting of toothbrushes and razors.
- 1 18. A method of manufacturing a toothbrush comprising:  
2 (a) forming a toothbrush handle; and  
3 (b) sandwich molding onto the handle a grip comprising a core and a sheath  
4 surrounding the core, the sheath having a hardness greater than that of the core.
- 1 19. A method of manufacturing a razor comprising:  
2 (c) forming a razor handle; and  
3 (d) sandwich molding onto the handle a grip comprising a core and a sheath  
4 surrounding the core, the sheath having a hardness greater than that of the core.
- 1 20. A method of manufacturing a personal care product comprising:

2 applying to a handle of a personal care product a grip comprising a core and a sheath  
3 surrounding the core.

1 21. A personal care product comprising:

2 (e) a handle; and

3 (f) a grip formed on the handle, the grip comprising a core and a sheath surrounding the  
4 core, the sheath having a hardness greater than the core.

1 22. The personal care product of claim 21 wherein the core is a elastomeric material.

1 23. The personal care product of claim 22 wherein the elastomeric material is a thermoplastic  
2 elastomer.

1 24. The personal care product of claim 23 wherein the thermoplastic elastomer is selected  
2 from the group consisting of thermoplastic vulcanates (rubber polyolefin blends),  
3 polyetheramides, polyesters, styrene-ethylene-butylene-styrene (SEBS) block copolymers,  
4 styrene-butadiene-styrene (SBS) block copolymers, partially or fully hydrogenated styrene-  
5 butadiene-styrene block copolymers, styrene-isoprene-styrene block copolymers,  
6 polyurethanes, polyolefin elastomers, polyolefin plastomers, styrenic based polyolefin  
7 elastomers, and compatible mixtures thereof.

1 25. The personal care product of claim 21 wherein the core has a hardness of less than 50  
2 Shore A.

1 26. The personal care product of claim 25 wherein the core has a hardness of less than 25  
2 Shore A.

1 27. The personal care product of claim 26 wherein the core has a hardness of less than 10  
2 Shore A.

1 28. The personal care product of claim 21 wherein the sheath is an elastomeric material.

A) 1 29. The personal care product of claim 28 wherein the elastomeric material is a thermoplastic  
2 elastomer.

1 30. The personal care product of claim 29 wherein the thermoplastic elastomer is selected  
2 from the group consisting of thermoplastic vulcanates (rubber polyolefin blends),  
3 polyetheramides, polyesters, styrene-ethylene-butylene-styrene (SEBS) block copolymers,  
4 styrene-butadiene-styrene (SBS) block copolymers, partially or fully hydrogenated styrene-  
5 butadiene-styrene block copolymers, styrene-isoprene-styrene block copolymers,  
6 polyurethanes, polyolefin elastomers, polyolefin plastomers, styrenic based polyolefin  
7 elastomers, and compatible mixtures thereof.

1 31. The personal care product of claim 21 wherein the sheath is approximately 0.4 mm to 4.0  
2 mm thick.

1 32. The personal care product of claim 31 wherein the sheath is approximately 0.5 mm to 2.0  
2 mm thick.

1 33. The personal care product of claim 32 wherein the sheath is approximately 0.5 mm to 1.0  
2 mm thick.

1 34. The personal care product of claim 21 wherein the sheath has a hardness of  
2 approximately 25 Shore A to 80 Shore A.

1 35. The personal care product of claim 34 wherein the sheath has a hardness of  
2 approximately 30 Shore A to 60 Shore A.

1 36. The personal care product of claim 35 wherein the sheath has a hardness of  
2 approximately 40 Shore A to 55 Shore A.

1 37. The personal care product of claim 21 wherein the handle is a toothbrush handle.

1 38. The personal care product of claim 21 wherein the handle is a razor handle.

A 1 39. The personal care product of claim 21 wherein the handle is a hairbrush handle.

1 40. A toothbrush comprising:

2 (a) a toothbrush handle; and

3 (b) a grip formed on the handle, the grip comprising a core and a sheath  
4 surrounding the core, the sheath having a hardness greater than the core.

1 41. A razor comprising:

2 (a) a razor handle; and

3 (b) a grip formed on the handle, the grip comprising a core and a sheath  
4 surrounding the core, the sheath having a hardness greater than the core.

1 42. A toothbrush comprising:

2 (a) a handle; and

3 (b) a grip formed on the handle, the grip comprising a core and a sheath  
4 surrounding the core.

1 43. A razor comprising:

2 (a) a razor handle; and

3 (b) a grip formed on the handle, the grip comprising a core and a sheath  
4 surrounding the core.

1 44. A method of manufacturing a personal care product comprising:

2 (a) applying to a handle of personal care product a grip comprising a first layer, a  
3 second outer layer surrounding the first layer; and

4 (b) forming a hollow core within the first layer by injecting a gas into the middle  
5 of the first layer.

1 45. A personal care product comprising:

2 (a) a handle, and

3 (b) a grip formed on the handle, the grip comprising a first layer, a second outer  
4 layer surrounding the first layer, and a hollow core within the first layer.

1 46. The personal care product of claim 21 wherein the core further comprises a foaming  
2 agent.

1 47. A handheld household appliance comprising:

2 (a) a handle; and

3 (b) a grip formed on the handle, the grip comprising a core and a sheath  
4 surrounding the core.

1 48. The handheld household appliance of claim 47 wherein the sheath has a hardness greater  
2 than the core.